



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5550-1

Job Sheet 170799



Part No: D5550-1

Job Qty: 2 ea

Part Name: Fwd Outboard Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/19/18

Job Tracking No:

Due Date: 2/26/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG D5550 REV.A SHEETS 3,5 IPP REV:A 17.09.05 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea			0.00	0.00	Start Up Waterjet		18/01/24
105	Waterjet	2 pcs			0.00	2.47	Waterjet1		18/01/24
110	QC	2 pcs			0.00	0.00	QC2 Waterjet-4		18/01/24
120	CNC Vertical Machining	2 pcs			0.00	4.92	HAAS1-1		18/01/24
130	QC	2 pcs			0.00	0.00	QC2 Machining-4		18/04/12
140	QC	2 pcs			0.00	0.00	QC8 Machining-4		18-04-12
150	HandFinish	2 pcs			0.00	0.49	HandFinish1		18-04-16
160	QC	2 pcs			0.00	0.00	QC7-5		18-04-17
170	Powdercoat	2 pcs			0.00	0.17	Powdercoat1		18-04-17
180	QC	2 pcs			0.00	0.00	QC3		11 APR 23 2018
190	Packaging	2 pcs			0.00	0.00	Packaging3-2	5/476	6 9-89 APR 23 2018
200	QC21-SA	2 Ea			0.00	0.00	QC21		9-89

Part Op 105 - ***GRAIN DIRECTION*** 1-Cut contour and pocket as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if Descriptions: necessary

120 - Face and Drills holes as per dwg Dwg Rev: _____

170 - ***Mask holes or blow out access powdercoat in holes*** START TIME: 1:45 OVEN TEMPERATURE: _____

300 FINISH TIME: 2:15 11/38760

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X12.000	6061-T6 Bar 1.00 X 12.00	4.3200 ft (2.16 ea)	90-Start up Operation	

DAS 10 6061T6B1.000X15.000 5008957 = 4.4 €

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION Fwd Outboard Beam  S035070 DART AEROSPACE	<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="4" style="text-align: left;">AGAINST DEPARTMENT/PROCESS</th> </tr> <tr> <td style="width:15%;"> Kid-tube Machining Forming Large Fab </td> <td style="width:15%;"> Cross tube Small Fab Finishing Composite </td> <td style="width:15%;"> Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier </td> <td style="width:15%;"> Engineering Quality Other </td> </tr> <tr> <td colspan="3"> Effective : _____ </td> <td rowspan="2"> MRB (QSI042) Approval </td> </tr> <tr> <td colspan="3" style="text-align: center;"> Disposition </td> </tr> <tr> <td colspan="3" rowspan="3" style="height: 150px;"></td> <td> Completed By </td> </tr> <tr> <td> Lead hand / Supervisor Approval Verification </td> </tr> <tr> <td> QC / QA Coordinator Approval </td> </tr> </table>	AGAINST DEPARTMENT/PROCESS				Kid-tube Machining Forming Large Fab	Cross tube Small Fab Finishing Composite	Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier	Engineering Quality Other	Effective : _____			MRB (QSI042) Approval	Disposition						Completed By	Lead hand / Supervisor Approval Verification	QC / QA Coordinator Approval												
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DART AEROSPACE LTD		Work Order:	170799
Description: was Fuel outboard Beam		Part Number:	DSS50-1
Inspection Dwg: SSSO Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	$-0.001 +0.012$	1.249	✓		Vernier	
2.00	$+/- .030$	1.998	✓		Tap	
2.00	$+/- .030$	1.999	✓			
1.93	$+/- .030$	1.928	✓			
3.50	$+/- .030$	3.513	✓			
3.50	$+/- .030$	3.508	✓			
6.72	$+/- .030$	6.712	✓			
0.377"	$+0.006/-0.001$	0.378"	✓		Vernier	CNC - 19
0.191"	" "	0.192"	✓		"	" "
0.06"	± 0.030 "	0.595/0.598"	✓		"	" "
0.63"	"	0.625"	✓		"	" "
1.800"	± 0.010 "	1.798/1.799"	✓		"	" "
3.600"	"	3.598"	✓		"	" "
2.300"	"	2.301/2.302	✓		"	" "
0.375"	"	0.377"	✓		"	" "
0.75"	± 0.030	0.750"	✓		"	" "
1.500"	± 0.010	1.501"	✓		"	" "
3.000"	"	3.001"	✓		"	" "
3.750"	"	3.750"	✓		"	" "
1.150"	"	1.150/1.148"	✓		"	" "

Measured by:	me / 18/4/12	Audited by:	DAC 20 9-88	Preliminary Approval:	
Date:	18/01/28	Date:	18-04-12	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	